

~~Must~~ must ship June 30

Work Order ID 70313



Page 1

Thursday, June 02, 2011 2:52:54 PM

Item ID: D4131-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 6/2/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: cd Date: 11/06/03 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4131

A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4131 as per Dwg

6061-003

Dwg Rev: B

Prog Rev: B

2-Deburr as required

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B11-6-6

9

B11-6-6

+9

Sulabub

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Approvals:

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

COUNTER SINK AS PER DWG

Deburr if necessary.

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Subtotal

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

EP 11/06/06 (9)

(XS)

9X 1/2 M 11/06/09

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Stop



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Start Date: 6/2/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

161

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

9 0 11-6-9

165

QC3- Inspect Part Finish

0.00



Small Fab

Memo

0.00

Small Fab

ASSEMBLE NUT PLATES AS PER DWG

E 5/11/06/09 (92)

166

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub 613

(2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Required Date: 6/17/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: 132

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Run Start Stop
11/6/13 (9)

11/6/14 (9)

11-06-13 (9)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 2:52:52 PM

Page 1

Work Order ID: 70313

Parent Item: D4131-043

Parent Item Name: Doubler Assembly




Start Date: 6/2/2011

Required Date: 6/17/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	286.5000	0.1807	0.760842			
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						MAT021		286.5					
						116308		30.5					
						117285		256					
MS20426AD3-3  Rivet		Purchased	No			165	Each	2,219.000	8	32			
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						ST316		2219					
						19099		2219					
MS21069L3  ANCHOR NUT		Purchased	No			165	Each	32.0000	4	16			
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						ST302		32					
						103447		1					
						115708		31					

B11-6-6

116 308

ES 11/06/09

72

ES 11/06/09

21

M118003 (12x)

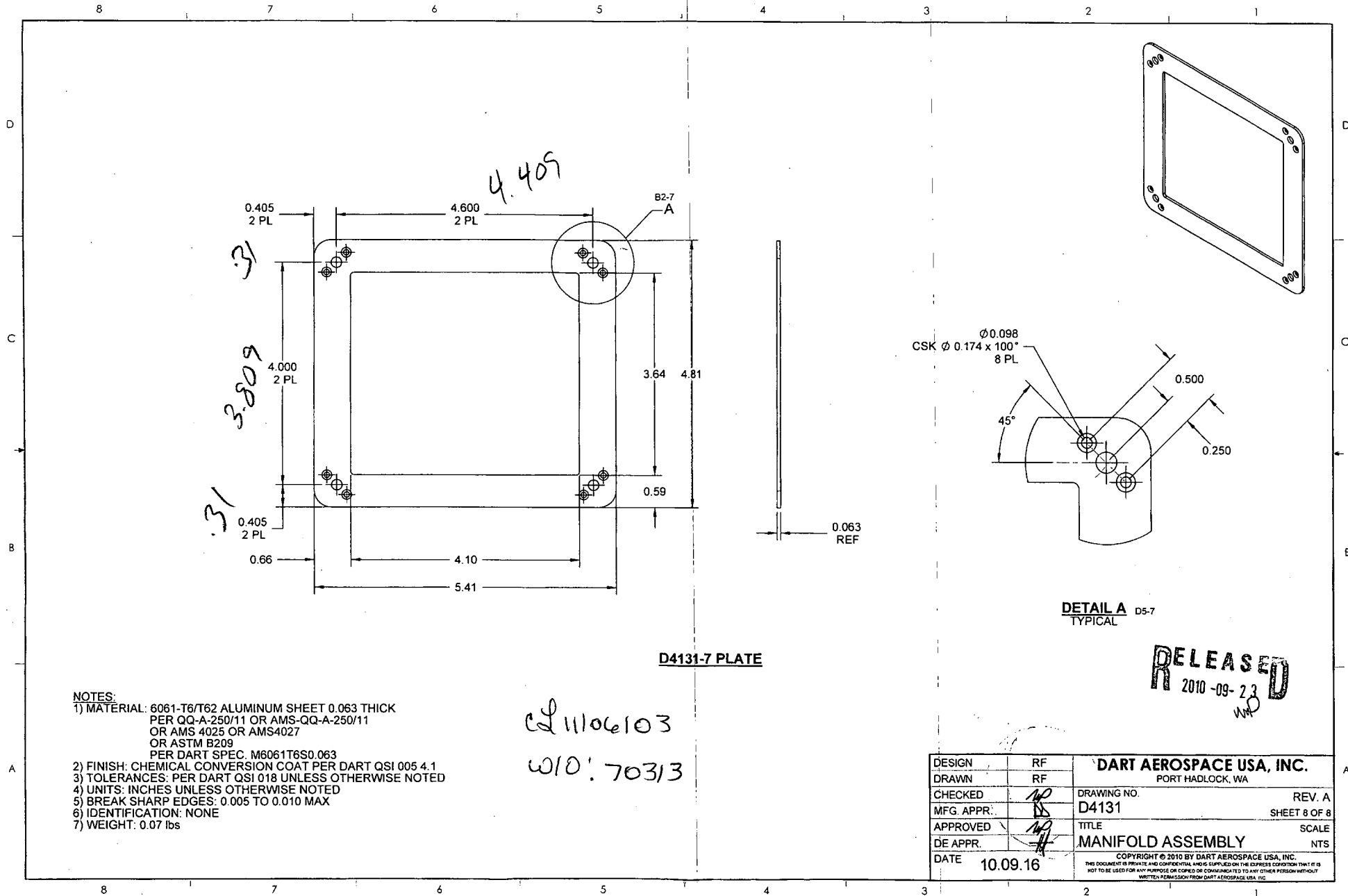
W/O:		WORK ORDER CHANGES						
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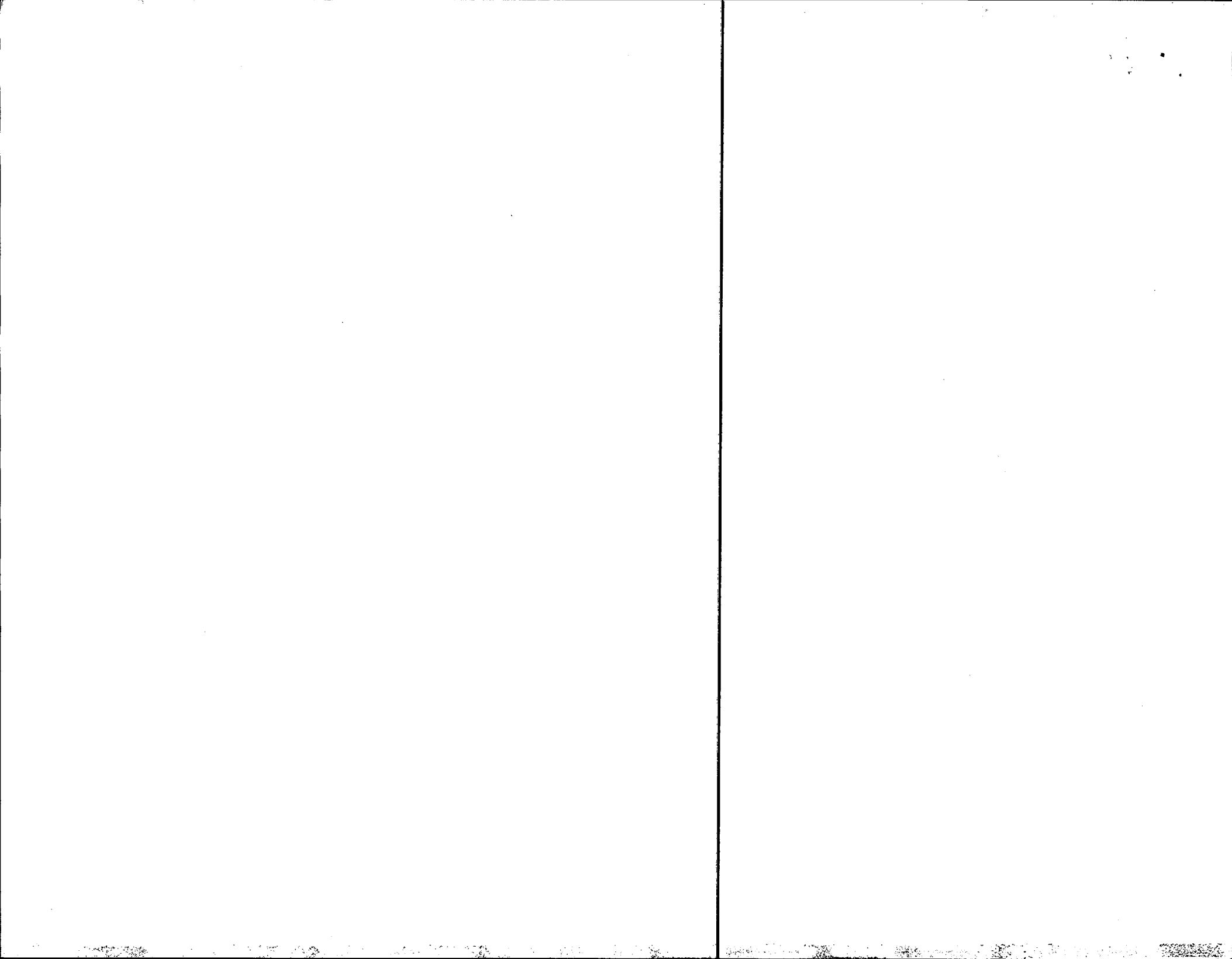
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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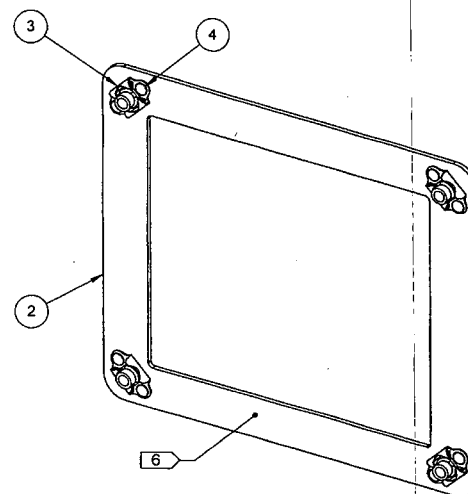
NOTE: Date & initial all entries







ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4131-043	DOUBLER ASSEMBLY
2	1	D4131-7	DOUBLER
3	4	MS21069L3	NUT PLATE
4	8	MS20426AD3-3	RIVET



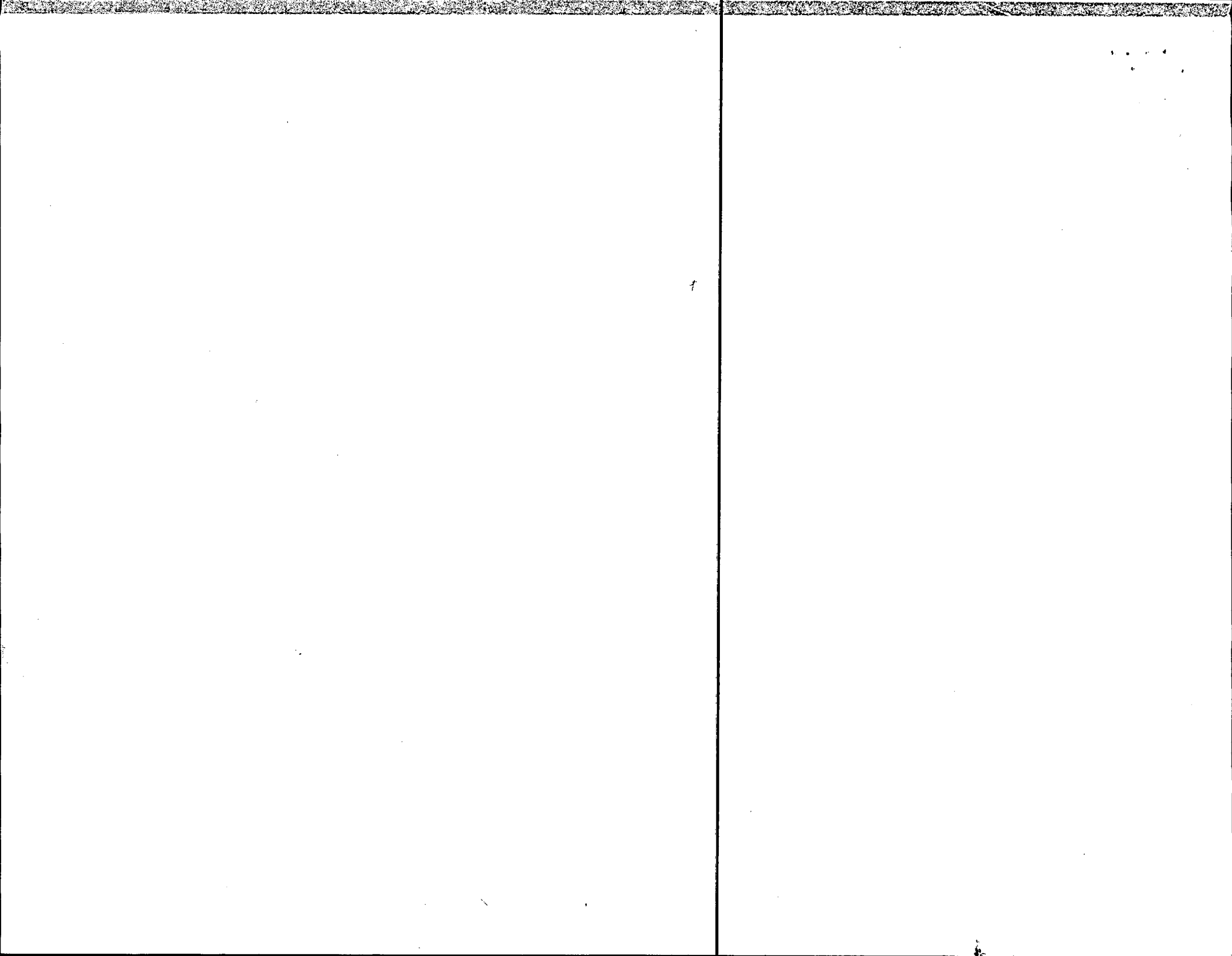
D4131-043 DOUBLER ASSEMBLY

RELEASED
2010-09-23
WFO

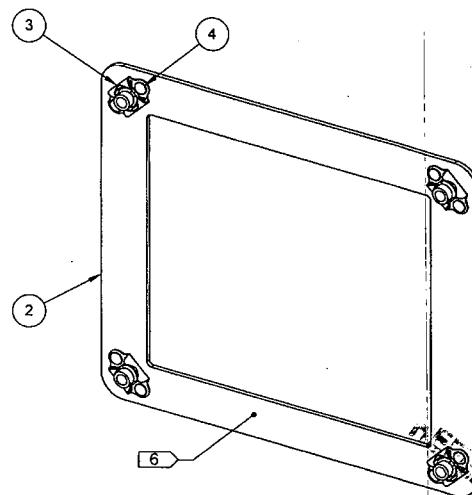
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4131	SHEET 2 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MANIFOLD ASSEMBLY	NTS
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4	8	MS20426AD3-3	RIVET



D4131-043 DOUBLER ASSEMBLY

REFERENCE ONLY

RELEASED
2010-09-23
wmp

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